

TENALLOY 16 W

CLASSIFICATIONS

AWS A/SFA 5.1 E7016
IS814 E B5426H,X

IDENTIFICATION: Name Printed

CHARACTERISTICS

A hydrogen-controlled electrode having special type of lime coating. Produces a smooth, clean deposit with very little spatter less slag is easy to remove, because of its special lime-type coating, trouble free welds, are possible on "difficult-to-weld" steels such as high carbon, alloy, high sulphur, free machining and cold rolled steels. The weld-metal is highly resistant to cracking. The welds are of radiographic quality.

TYPICAL APPLICATIONS

- High carbon steel parts • High carbon steel to mild steel • Low-alloy steels • Steels relatively high in sulphur amour plates
- Cast steels • Steel of unknown composition • Suitable for joining steels conforming to ASTM specification:
- C, D, E grades of SA-414/SA-414M (P. No. 1)

WELD METAL CHEMISTRY (%)

| | |
|------------------|--------------|
| C - 0.04 - 0.10 | S - 0.03 max |
| Mn - 0.60 - 1.10 | P - 0.03 max |
| Si - 0.25 - 0.55 | |

MECHANICAL PROPERTIES- ALL-WELD

| Condition | UTS MPa | YS MPa | % Elong. (L=4xd) | CVN Impact, J 27±2°C -30 C |
|-----------|------------|-----------|---------------------|-------------------------------|
| As-welded | 500-550 | 400-470 | 24-32 | 150-200 50-60 |

CURRENT CONDITIONS: AC (90V) or DC (+)

| | | | | |
|---------|---------|---------|--------|-------|
| 6.3 | 5.0 | 4.0 | 3.2 | 2.5 |
| 230-310 | 180-240 | 130-180 | 90-130 | 60-85 |

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition.)

PACKING DATA

| | 6.3 | 5.0 | 4.0 | 3.2 | 2.5 |
|----------------------------|-----|-----|-----|-----|------|
| Dia., mm | 6.3 | 5.0 | 4.0 | 3.2 | 2.5 |
| Length, mm | 450 | 450 | 450 | 450 | 350 |
| Pcs per carton, Nos | 35 | 49 | 86 | 132 | 285 |
| Cartons / box | 4 | 4 | 4 | 4 | 4 |
| Pcs per box, Nos | 140 | 196 | 344 | 528 | 1140 |
| Approx. Wt. of 1000 pcs,kg | 143 | 100 | 58 | 38 | 18 |



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ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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